

Work Order ID 67561

Monday, March 28, 2011 11:07:13 AM



Ship
(1st week April)

Page 1

Item ID: D4038-10

Accept



Setup Start



Revision ID:

Stop



Item Name: Block

Start Date: 3/28/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 4/5/2011 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: ME Date: 11-03-28

Tooling:

Date:

Run Start



QC: Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4038

D

100

0.00



Bandsaw

Memo

0.00

Jeaspa Bandsaw

CUT BLANK 1.750" LONG

cut 11/03/29

3

0

105

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Mill as per Dwg and Folio FA885

DWG REV: ADD

FOLIO REV: AA

DEBURR

cut 11/03/30

3

0

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 3

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Revision ID:					Stop	
Item Name:	Block					
Start Date:	3/28/2011	Start Qty: 3.00		Cust Item ID:		
Required Date:	4/5/2011	Req'd Qty: 3.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				3		BR 3-11-31	
160 Packaging Packaging	Identify as per dwg & Stock Location: <u>GA</u> Memo <u>B 67550</u>	0.00 0.00		<u>83 116464</u>		<u>3</u>			
170 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						<u>11/4/14</u>	

11/4/14
3

W/O:		WORK ORDER CHANGES						
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Picklist Print

Monday, March 28, 2011 11:07:10 AM

Page 1

Work Order ID: 67561



Parent Item: D4038-10



Parent Item Name: Block

Start Date: 3/28/2011

Required Date: 4/5/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: Ipp Rev:A New Issue 09-12-14 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X02.00 0		Purchased	No				f	11.0000		0.524211			



6061-T6 Bar 1.50 x 2.00

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT010	11	
110167	1	
→ 114608	10	

.524 *only 11/03/29*

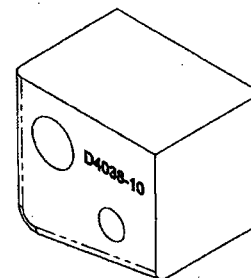
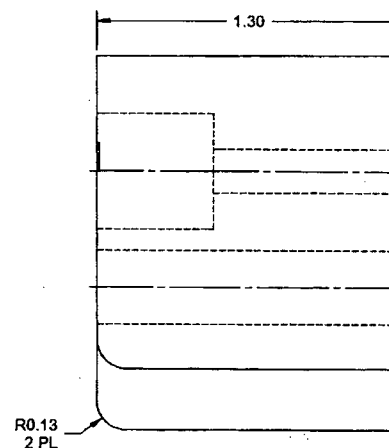
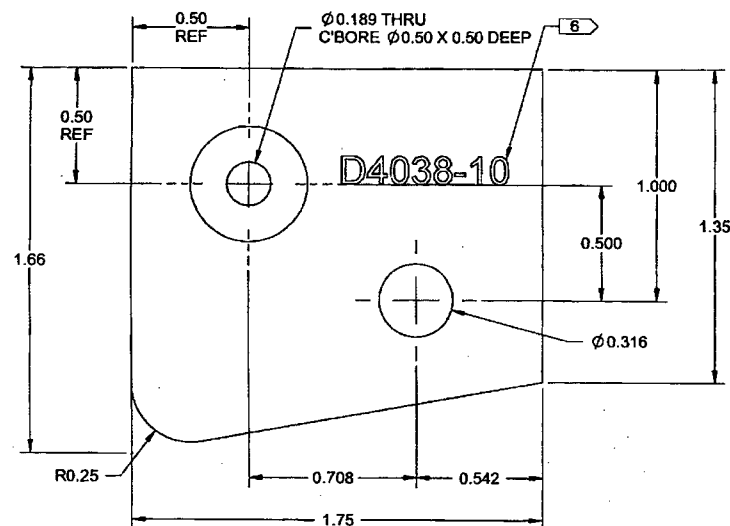
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
NOTE: Date & initial all entries



D4038-10 BLOCK

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T6511/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN TO MAX DEPTH
OF 0.010 IN 0.12 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015
- 7) WEIGHT: 0.31 lbs

DESIGN			DART AEROSPACE LTD	
DRAWN			HAWKESBURY, ONTARIO, CANADA	
CHECKED			DRAWING NO. D4038	REV. F
MFG. APPR.				SHEET 12 OF 14
APPROVED			TITLE	SCALE
DE APPR.			BRACKET	NTS
DATE	11.03.03	COPYRIGHT © 2009 BY DART AEROSPACE LTD		
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RELEASED
2011-03-17
JW

#67561

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